

Date: Tuesday, 11/29/2005 4:36:36 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING LUG ASSEMBLY
Job Number	: 25025		
Estimate Number	: 10816		
P.O. Number	: N/A	Part Number	: D3175041
This Issue	: 11/29/2005 S.O. No. : N/A	Drawing Number	: D3175 REV. A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 24895C	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 12/6/2005
Checked & Approved By	: <u>SEE COMMENT BELOW</u>	Qty:	16 Um: Each
Comment	: Est:B 03.02.28 Modify Step 1,2,3,4,21,23 KJ/RF		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1500X02500	6061-T6 Bar 1.5" x 2.5"
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Comment: Qty.: 0.2012 f(s)/Unit Total: 3.2189 f(s)  
 Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-250/11)  
 (M6061T6B1.500x02.500) Batch: M16742

1612

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW  
 (2) blanks required per (1) D3175-041 assembly  
 Cut blanks: 2.5" x 1.5" x 2.2" (grain along 2.2")

M8 05/12/07

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine as per Folio FA293 and Dwg D3175  
 Deburr and Tumble  
 Identify as D3175-1

J.G.

M8 05/12/07

16

Pto

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.G / M8 05/12/07 16

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SA 05.12.09 16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3175-041 PAR #: \_\_\_\_\_ Fault Category: Prod/machine probs NCR: Yes No DQA: DD Date: 06/02/16  
 QA: N/C Closed: FA Date: 06/02/16

NCR: <u>25025</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>05/12/12</u>	<u>3</u>	<u>1 SCRAP part came out of vice</u> <u>1 SCRAP holes in wrong place</u>	<u>JB</u> <u>PROD</u>	<u>excess material removed on bandsaw</u> <u>part no longer pulls out of vice.</u> <u>-change the RIGINS</u> <u>SCRAP - replace</u>	<u>J.G</u> <u>05/12/09</u>	<u>2</u> <u>05-12-12</u>	<u>JB</u> <u>05/12/12</u>	<u>2</u> <u>05-12-12</u>

NOTE: Date & initial all entries

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Drawing Name: MOUNTING LUG ASSEMBLY

Job Number: 25025

Part Number: D3175041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

FF 05/12/14

16

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

25-12-14

16

8.0 D31753 Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 16.0000 Each(s)

Spacer D 3175-3

4 B 24890A

26-050027

Pick:

B 22409

Qty Part Number Description Batch  
1 D3175-3 Spacer

2 B 24895A

26-250027

SB 05/12/15

18

9.0 AN37A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 32.0000 Each(s)

Bolt

Pick:

Qty Part Number Description Batch  
2 AN3-7A Bolt

M 5288

SB 05/12/15

18

10.0 AN960JD10L Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 64.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch  
4 AN960JD10L Washer

M 18235

SB 05/12/15

18

11.0 MS21042L3 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 32.0000 Each(s)

Nut

Pick:

Qty Part Number Description Batch  
2 MS21042L3 Nut

M 17652

SB 05/12/15

18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/02/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 25025

Part Number: D3175041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble as per Dwg D3175

DL 05/12/16 13

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Pos-12-16 13

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3

9. m 04-02-13

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/2/15 13

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: ST 130

06/2/15 13

17.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

06/02/16 13

Job Completion



U 06.03.07

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>D3065-5DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> Bracket		<b>Part Number:</b>	D3175-1
<b>Inspection Dwg:</b> D3175 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.191	+0.005/-0.000	Ø.191	✓			
Ø0.316	+0.005/-0.000	Ø.316	✓			
R0.25	+/-0.030	R.25	✓			
0.713	+/-0.010	.707	✓			
0.125	+/-0.010	.127	✓			
2.130	+/-0.010	2.131	✓			
1.000	+/-0.010	.991	✓			
0.125	+/-0.010	.119	✓			
1.730	+/-0.010	1.730	✓			
0.700	+/-0.010	.700	✓			
0.500	+/-0.010	.500	✓			
2.000	+/-0.010	2.001	✓			
1.000	+/-0.005	1.000	✓			

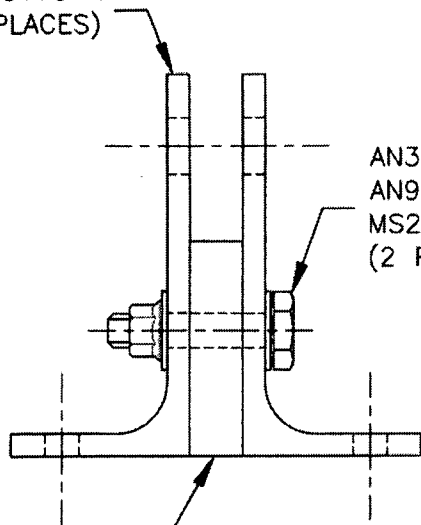
<b>Measured by:</b> MB	<b>Audited by:</b> JML	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 05/12/07	<b>Date:</b> 05/12/07	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	KJ/RF	

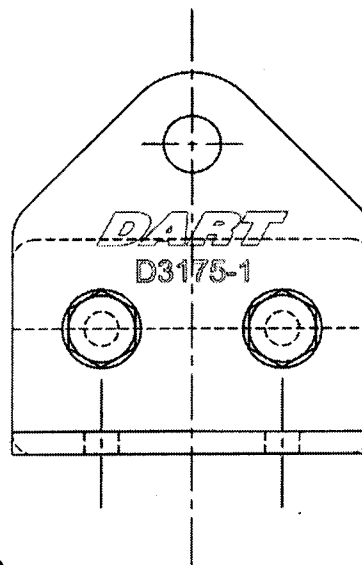


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3175	REV. A SHEET 1 OF 2
DATE 02.12.03		TITLE MOUNTING LUG	SCALE 1:1
A	02.12.03	NEW ISSUE	

D3175-1  
(2 PLACES)



AN3-7A BOLT (1)  
AN960JD10L WASHER (2)  
MS21042L3 NUT (1)  
(2 PLACES)

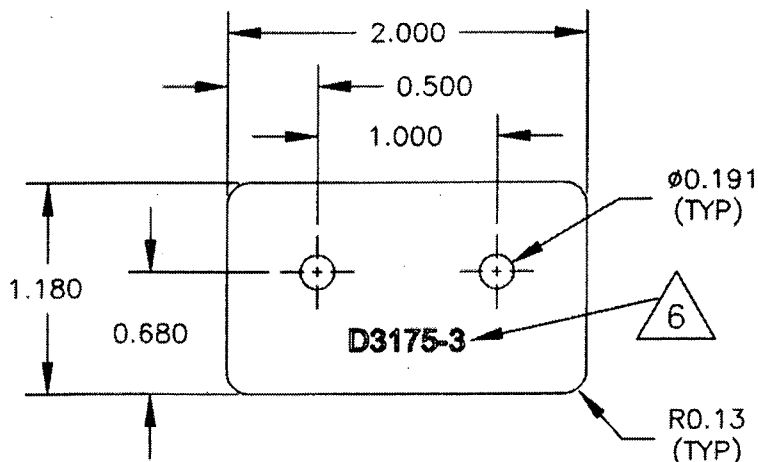


D3175-3

### D3175-041 MOUNTING LUG

FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1)  
PER DART QSI 005 4.3

RELEASED  
02.12.03 *#*



### D3175-3 SPACER

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.285 TO 0.290 THICK  
(QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)  
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE P/N IN THIS AREA AS SHOWN TO A DEPTH OF 0.010 MAX

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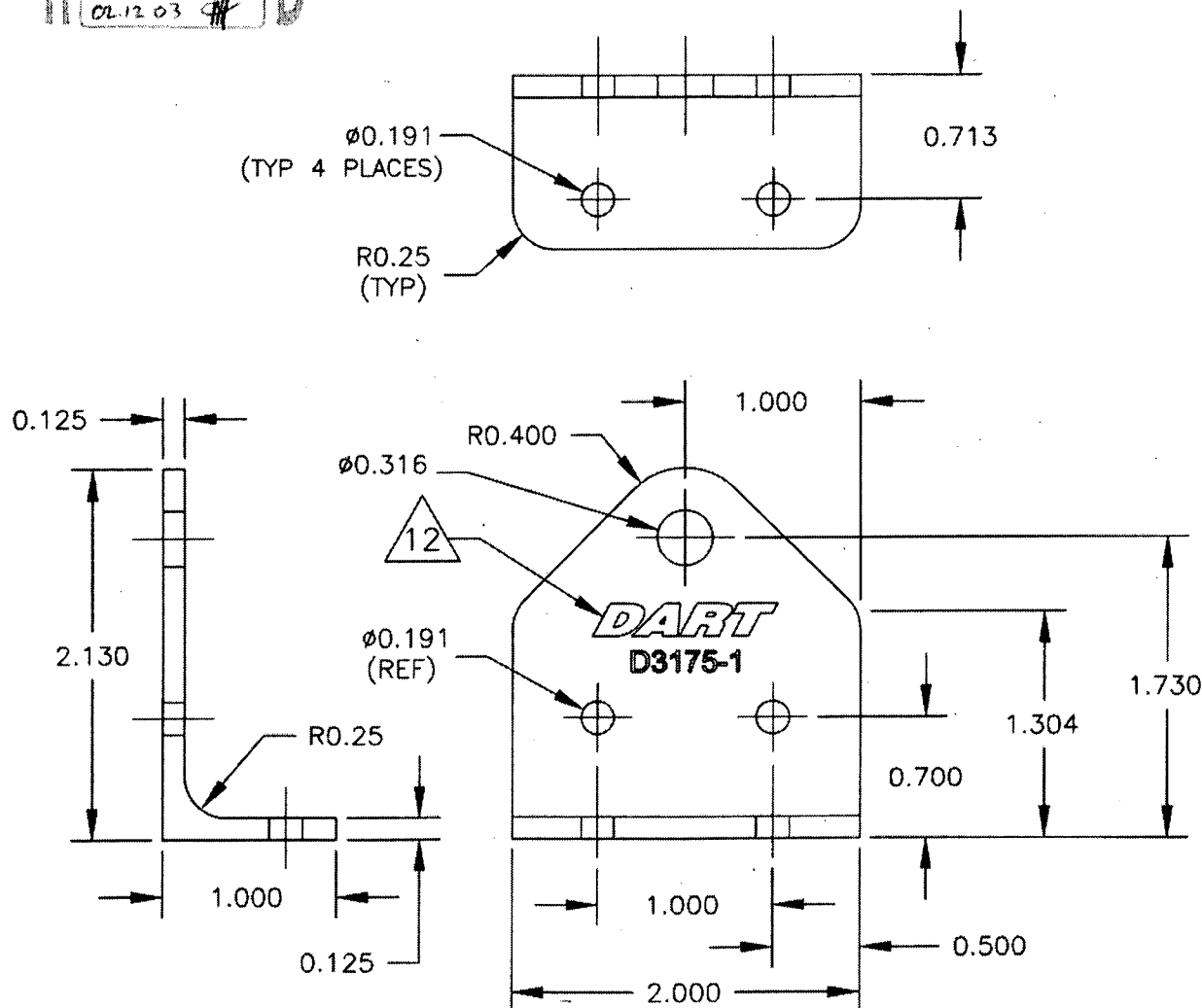
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DESIGN UP	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3175	REV. A SHEET 2 OF 2
DATE 02.12.03		TITLE MOUNTING LUG	SCALE 1:1

RELEASED  
02.12.03



#### D3175-1 BRACKET

7) MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)  
(REF DART SPEC. M6061T6B)

8) BREAK ALL SHARP EDGES 0.005 TO 0.015

9) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

11) ALL DIMENSIONS ARE IN INCHES.

12) ENGRAVE DART LOGO & P/N IN THIS AREA AS SHOWN TO A DEPTH OF 0.010 MAX.

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